

Date: Friday, 9/14/2007 2:00:47 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING
Job Number : 34671	
Estimate Number : 10844	
P.O. Number :	Part Number : D2249041
This Issue : 9/14/2007 S.O. No. :	Drawing Number : D2249 REV. E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 31609	Material :
Written By :	Due Date : 10/20/2007 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: D 05.02.04 Added Step 9 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	34671A	LUG
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Comment: Sub-Component LUG
 D2249-1 B 31072

sf 07/11/03

(10x)

2.0	34671B	LUG
-----	--------	-----



Comment: Sub-Component LUG
 D2249-3 B 31609B

sf 07/11/03

(10x)

3.0	34671C	GUSSET
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Comment: Sub-Component GUSSET
 D2249-5 B 34671

sf 07/11/03

(10x)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 Weld as per Dwg D2249 and QSI 004

sf 07/11/04

(10x)

5.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

PD 07-11-05

(10)

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

sf 07/10/05 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:00:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 34671

Part Number: D2249041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M105914 AS



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m.f. 07/11/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS



07/11/06

Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SI-198A

AS 07/11/06

10.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.11.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

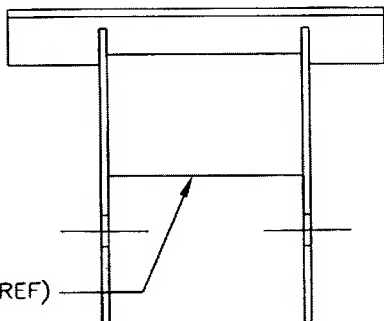
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

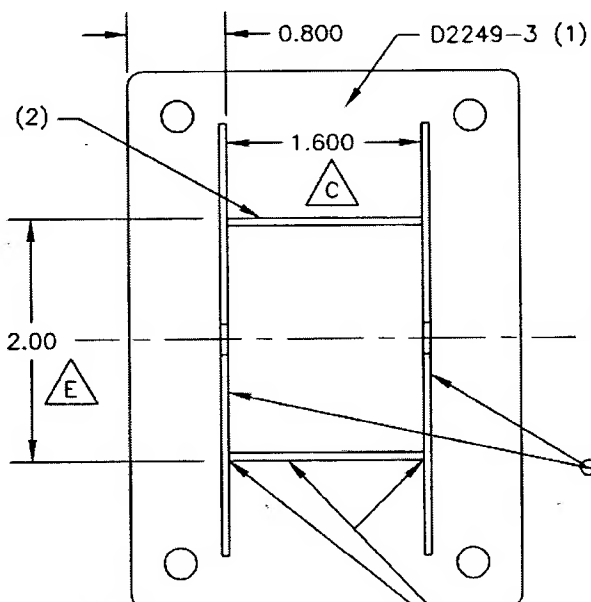
NOTE: Date & initial all entries

DART**RELEASED**
99.10.12 KLB

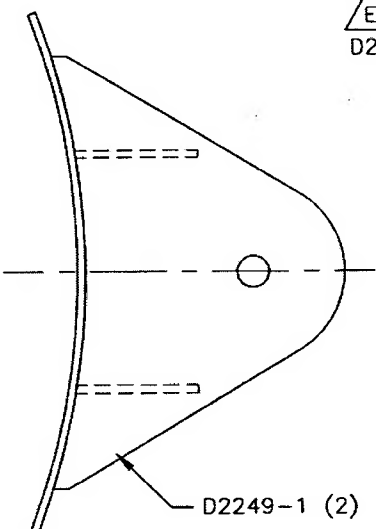
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
AE	RF	DRAWING NO.	REV. E
AE	RF	D2249	SHEET 1 OF 4
DATE		TITLE	SCALE
99.09.20		FITTING	NTS
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



E D2249-5 (REF)

WELD
USING TOOL
DT8209D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



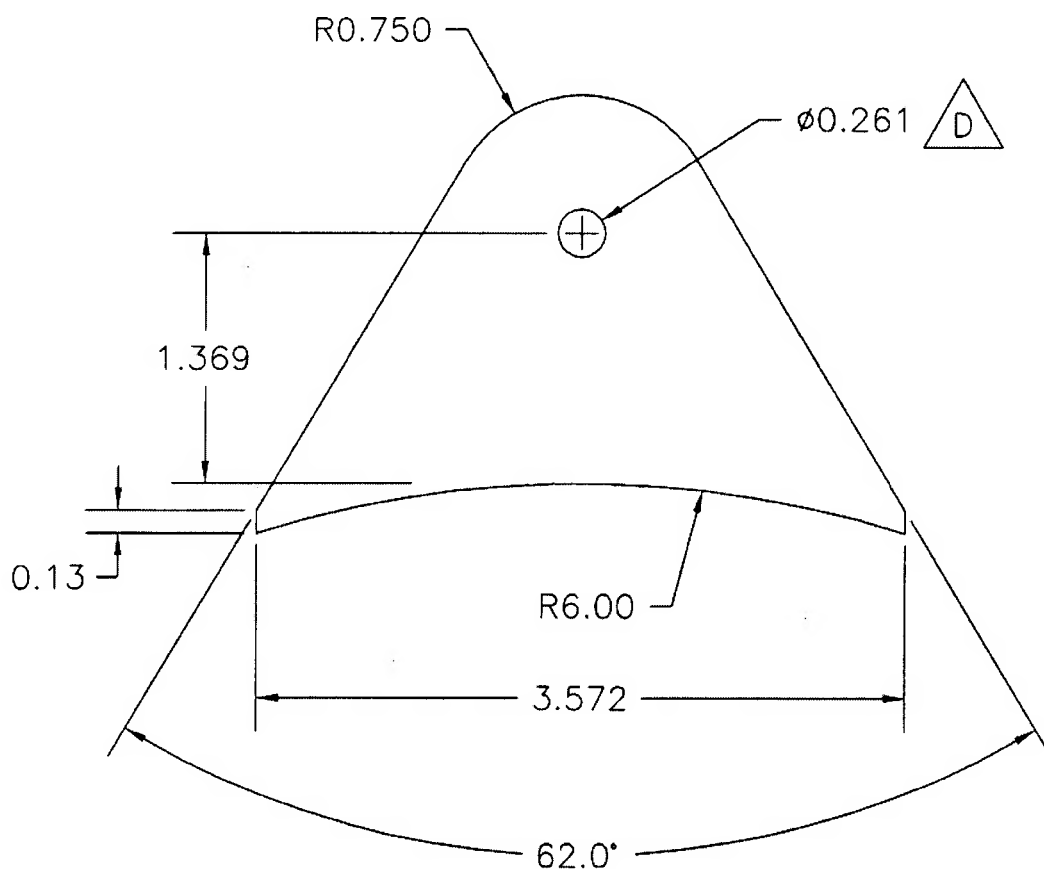
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WITHOUT NOTICE

WORK ORDER
34621



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CHECKED KE	APPROVED 	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KE



D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

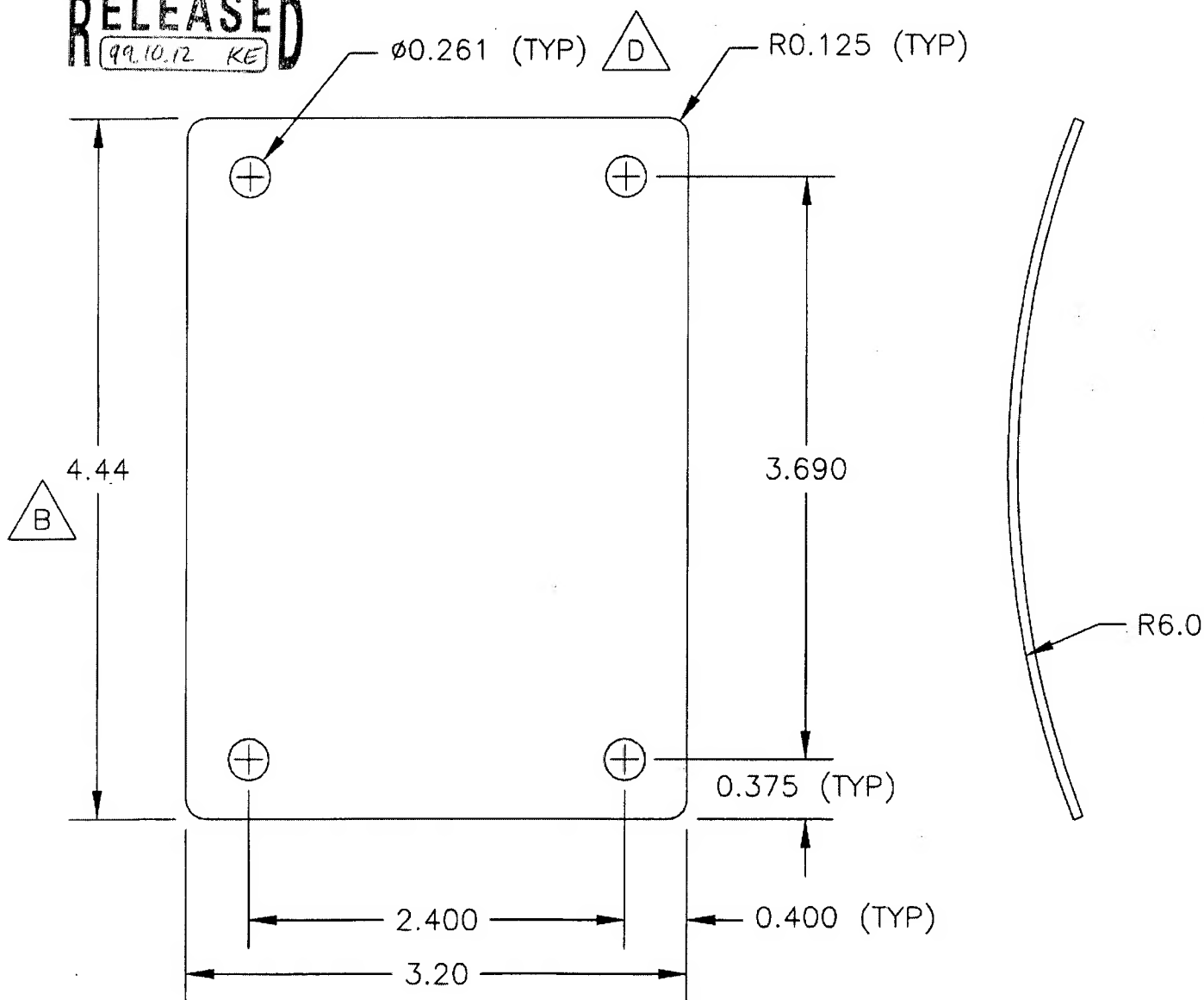
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NO 34671



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DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED
99.10.12 KE



FLAT PATTERN

BEND DETAIL

D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

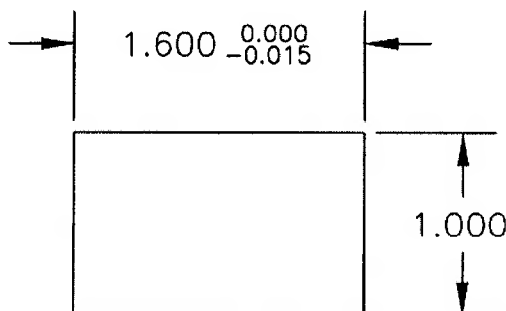
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NO. 34671



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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING SCALE 1:1	

RELEASED
19.10.12 KE



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

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